

Shg Entry 14/10

Work Order ID 74635

Tuesday, October 04, 2011 1:42:39 PM



Page 1

Item ID: D3914-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Lid Assembly (350)

Start Date: 10/4/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 11/10/04

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3914

B

100

Weld per dwg A/R S.S. rod Batch: 1117881 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble ribs , weld as per dwg D3914 using DT9607A
2- weld hinge (3) and Mounting brackets as per dwg D3914
inspect before welding mesh
3- tack weld mesh on basket as per dwg D3914
***make sure to place mesh correctly on lid, check with label plate before
tacking mesh***

Pl / 8MB 11/10/12

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

BE
11-10-12 1 0

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Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

8 w/10/13

130

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

*** mask sides of hinge prior to powdercoat***

Start Time: 8:45

Oven Temperature: 320°F

Finish Time: 9:15

1 X Ø m-f 11/10/13

140

Wing Walk as per dwg QSI005 4.4 Batch M118888

0.00



HandFinish

Memo

0.00

Hand Finishing

1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

2- Install placard and label as per dwg

***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

1 Ø m-f 11/10/13

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Picklist Print

Tuesday, October 04, 2011 1:42:35 PM

Page 1

Work Order ID: 74635

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 10/4/2011

Required Date: 10/14/2011


Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
as per dwg revB DD 10.08.18 verified by:EC


IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2581  Mounting Bracket		Manufactured	No			100	Each	18.0000	2	2		11/10/12	
--	--	--------------	----	--	--	-----	------	---------	---	---	--	----------	--


Location Loc Qty Loc Code

WA 18
69739 2
70766 2
73079 14

D3914-1  Rib		Manufactured	No			100	Each	1.0000	2	2		11/10/12	
---	--	--------------	----	--	--	-----	------	--------	---	---	--	----------	--


Location Loc Qty Loc Code

WA 1
72656 1

D3914-7  Rib		Manufactured	No			100	Each	0.0000	2	2		11/10/12	
---	--	--------------	----	--	--	-----	------	--------	---	---	--	----------	--

Location Loc Qty Loc Code

WA 18
73630 18
WA005 1
71941 1

D4016-3  Hinge Half, Lid		Manufactured	No			100	Each	19.0000	3	3		11/10/12	
---	--	--------------	----	--	--	-----	------	---------	---	---	--	----------	--

B72116 → ③

11/10/12

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Tuesday, October 04, 2011 1:42:35 PM

Page 2

Work Order ID: 74635

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 10/4/2011

Required Date: 10/14/2011

Start Qty: 1.00

Required Qty: 1.00

D4018-5 Manufactured No

100

Each

5.0000

9

9



Rib

B 73943

Location

Loc Qty

Loc Code

WA

5

70758

5

D4020-5 Manufactured No

100

Each

2.0000

1

1



Mesh (350 Basket Long, Lid)

B 73935

Location

Loc Qty

Loc Code

WA

2

68234

1

69162

1

D4021-3 Manufactured No

100

Each

7.0000

1

1



Data Plate

Location

Loc Qty

Loc Code

WA

7

71943

1

73632

6

D4035-041 Manufactured No

100

Each

0.0000

1

1



Lid Rib Assembly, Fwd (350 Basket)

B 73634

D4035-043 Manufactured No

100

Each

5.0000

1

1



Lid Rib Assembly, Aft (350 Basket)

Location

Loc Qty

Loc Code

WA006

5

73628

5

Tuesday, October 04, 2011 1:42:36 PM

Shop Packet Print

Page 2

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 3

Work Order ID: 74635



Parent Item: D3914-041



Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 10/4/2011

Required Date: 10/14/2011

Start Qty: 1.00

Required Qty: 1.00

D2728-3

Manufactured No

140

Each

0.0000

1

1



Dart Logo label



(X1) 1115.050 26 11/10/13

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ITEM	QTY	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 74635 M.L.J

11/10/04

D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.17
E.N. 10-596

B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.		MB	10.08.05
A	NEW ISSUE		JPH	10.03.16
REV.	DESCRIPTION		BY	DATE
DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3914 TITLE LONG BASKET LID ASSY (350) SCALE NTS <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		
DRAWN	SC			
CHECKED	SC			
MFG. APPR.	SC			
APPROVED	SC			
DE APPR.	SC			
DATE	10.08.05			

W/O:		WORK ORDER CHANGES					
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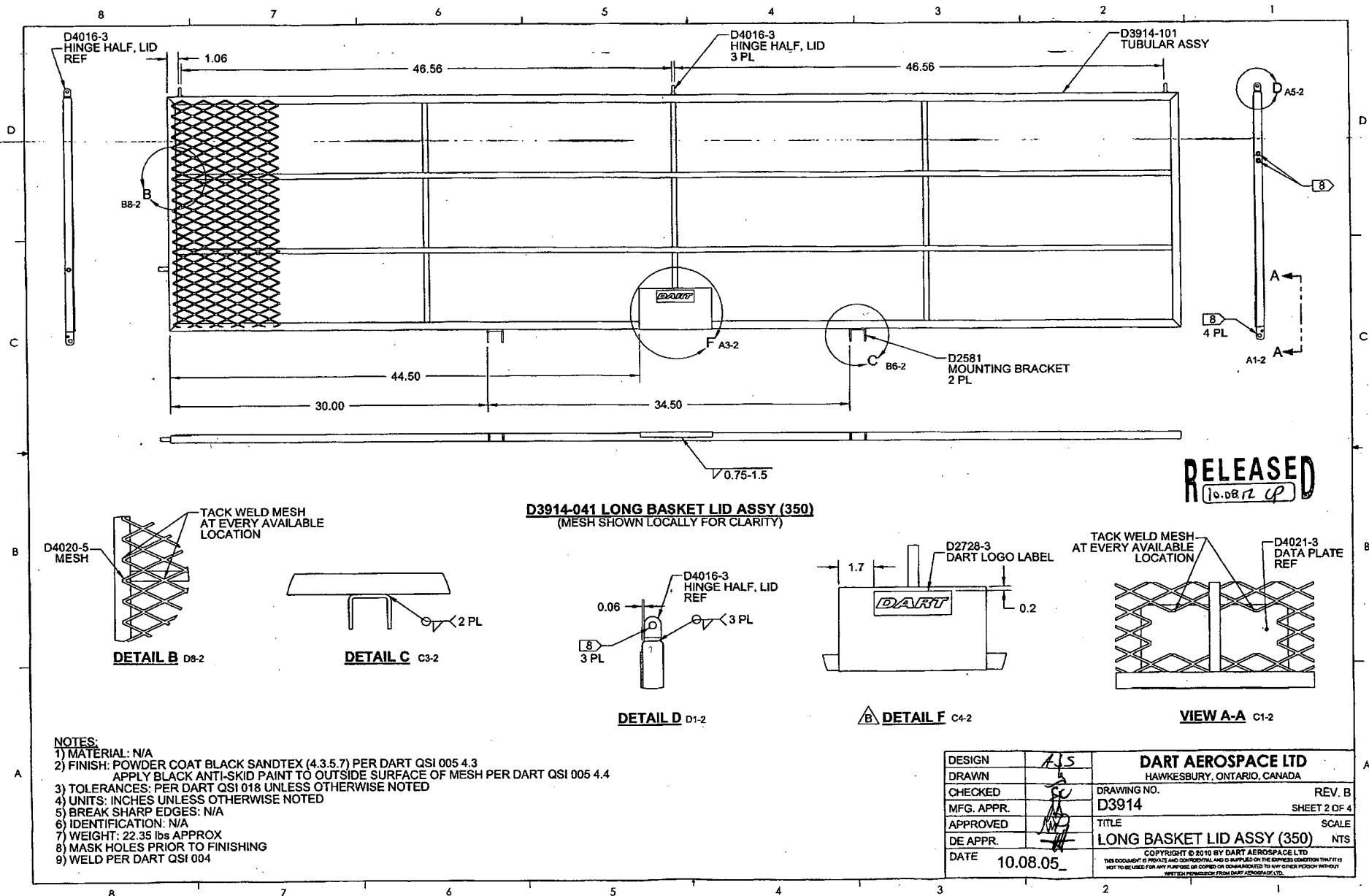
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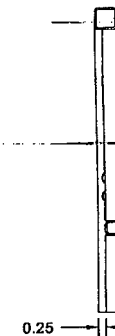
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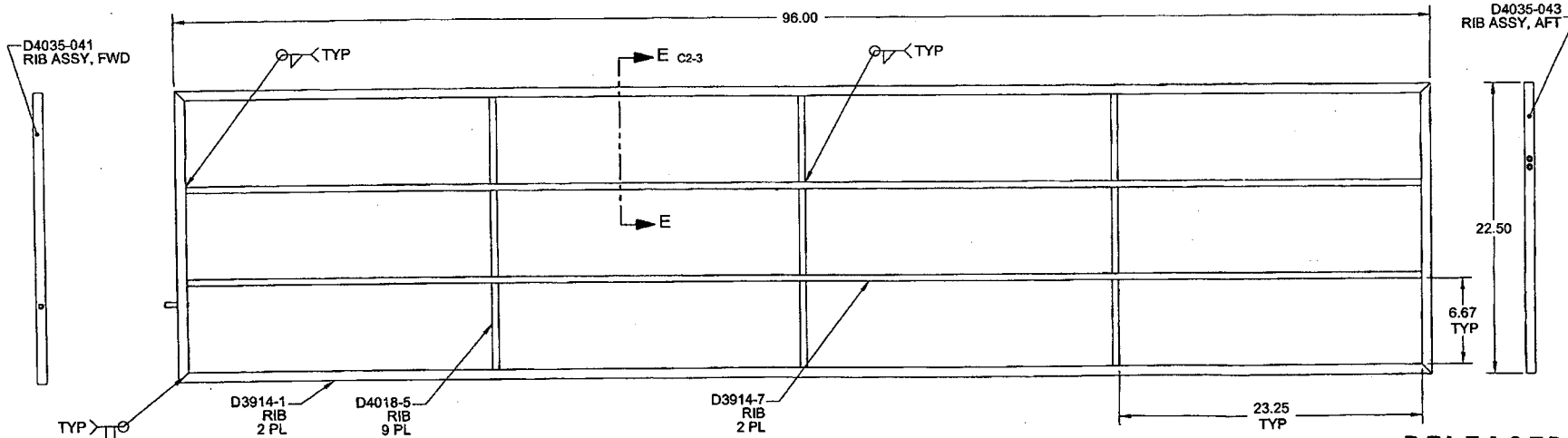
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74635

ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3



8 D3914-101 TUBULAR ASSY, LONG LID

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

RELEASED
10-08-12

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	AC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AC	DRAWING NO.	REV. B
MFG. APPR.	AC	D3914	SHEET 3 OF 4
APPROVED	AC	TITLE	SCALE
DE APPR.	AC	LONG BASKET LID ASSY (350)	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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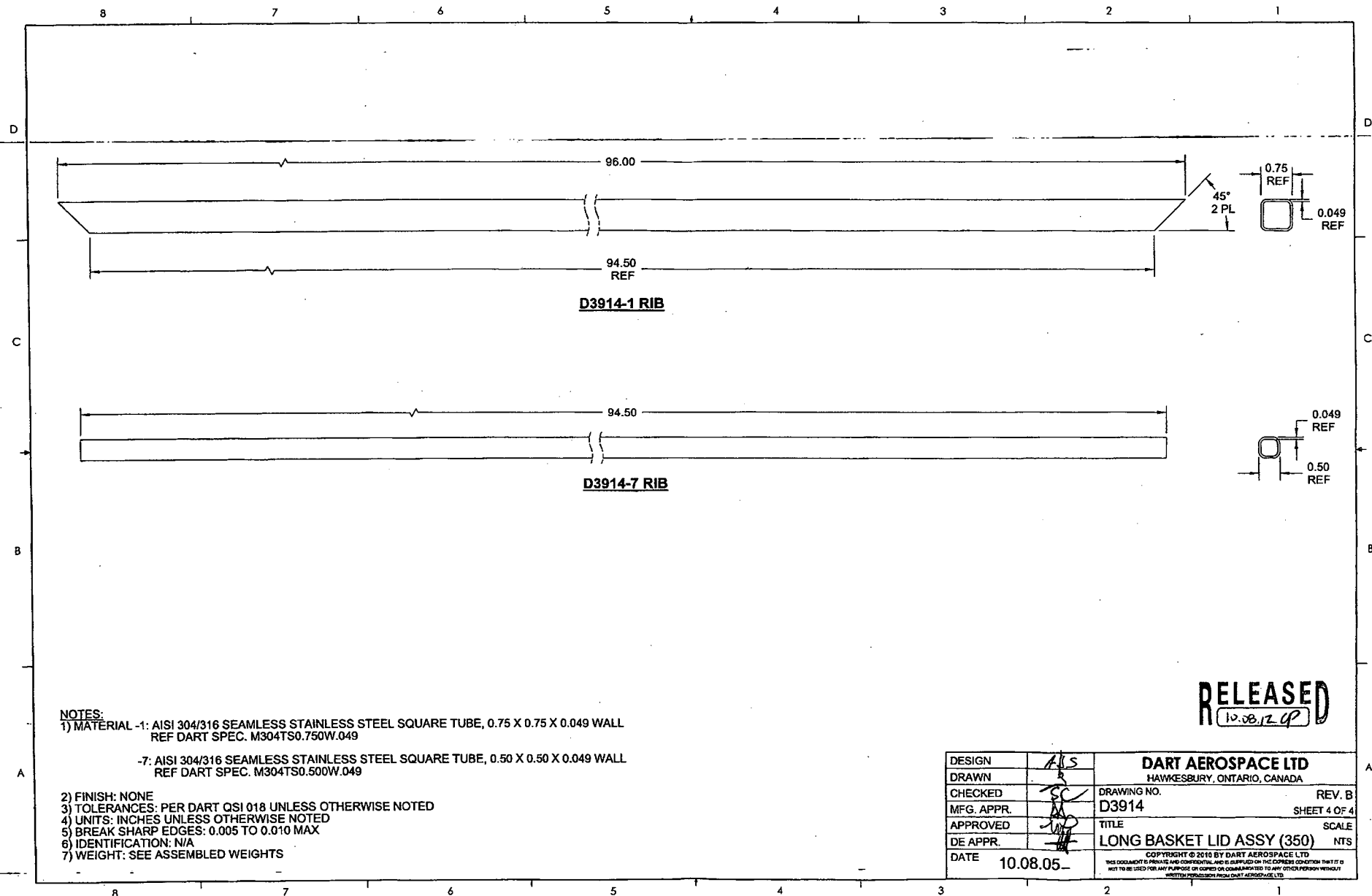
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